

Work Order ID 65939

Thursday, January 27, 2011 1:11:30 PM



Page 1

Item ID: D4017-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Base Assembly (350)

Start Date: 1/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/14/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: UMF

Date: 11-01-27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4017

C

100

Weld per dwg A/R S.S. rod Batch: M114649 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D4017 using DT9610B
inspect before welding mesh
2- tack weld mesh on basket as per dwg D4017 and trim mesh to fit if necessary
and trim to clear fasteners holes on the ends
3- weld hinge (3) and Mounting brackets as per dwg D4017
take lid to locate hinge and bracket

11/02/15 (1x)

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

11-02-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/2/16

(71)

125



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

1 8 11/10/2/16

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Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/02/16

MF
11-02-16

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Picklist Print

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Page 1

Work Order ID: 65939

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg RevA DD 10.03.06 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 10.11.04 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

✓ D4017-1 Rib		Manufactured	No			100	Each	3.0000	1	1			
------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

WA

3

65385

3

✓ D4017-3 Rib		Manufactured	No			100	Each	0.0000	1	1			
------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

✓ D4017-5 Hinge Rib		Manufactured	No			100	Each	0.0000	1	1			
------------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

✓ D4017-7 Rib		Manufactured	No			100	Each	8.0000	1	1			
------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

WA

8

58929

2

64681

3

65850

3

(1x)

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Page 2

[illegible][illegible]

Parent Item Name: Short Basket Base Assembly (350)

Required Date: 2/14/2011

Required Qty: 1.00

100	Each	4.0000	2	2
-----	------	--------	---	---



B65911 (2) *MS* 11/02/11

Loc Code

4

4

100	Each	6.0000	2	2
-----	------	--------	---	---



B65921 (2x) 11/02/11

Loc Code

6

6

100	Each	7.0000	1	1
-----	------	--------	---	---

1111

B65429 (1x) - 11/02/11

Loc Code

7

1

6

100	Each	0.0000	1	1
-----	------	--------	---	---

11

B65-785 (1x) M 11/02/11

100	Each	0.0000	1	1
-----	------	--------	---	---

B66094 (1x) *SY* 11/02/11

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Page 2

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Page 3

Work Order ID: 65939

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

D2581 Manufactured No

100 Each

29.0000

2

2



Mounting Bracket

Location

Loc Qty

Loc Code

WA

29

64112

20

64425

9

D3913-15

Manufactured No

100 Each

11.0000

1

1



Wide Handle Plate

Location

Loc Qty

Loc Code

WA

11

63627

1

64900

4

65851

6

D4016-1

Manufactured No

100 Each

10.0000

3

3



Hinge Half, Base

Location

Loc Qty

Loc Code

WA

10

64264

1

65374

9

D4020-3

Manufactured No

100 Each

0.0000

1

1



Mesh (350 Basket Short, Base)



B64112 (2x) MY 11/02/11



MY 11/02/11



B65849 (2x) MY 11/02/11



B65907 (1x) MY 11/02/15

W/O:		WORK ORDER CHANGES					
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Work Order ID: 65939

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D4020-11 Manufactured No



End Mesh, Basket

100 Each

8.0000

2 2



365933 (2x) BY 11/02/15

Location

Loc Qty

Loc Code

WA

8

59413

1

61306

1

64923

6

D2931



Bumper

Manufactured No

150 Each

734.0000

2 2



BY 10/11/16

Location

Loc Qty

Loc Code

ST504

734

46064

734

✓ D4021-1



Handle Plate

Manufactured No

100 Each

27.0000

3 3



46067
BY 11/02/11

Location

Loc Qty

Loc Code

ST109

5

57086

5

WA

22

64136

1

64903

9

65848

12

D4021-5



Blanking Plate

Manufactured No

150 Each

8.0000

2 2



(3x)
BY 1/2/16

Location

Loc Qty

Loc Code

ST112

8

64243

8

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Page 4

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 5

Work Order ID: 65939

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-10A Purchased No 150 Each 117.0000 6 6
Bolt

Location	Loc Qty	Loc Code
ST351	117	
115877	1	
116075	16	
116400	100	

AN960JD8 NAS1149DN832J Purchased No 150 Each 10.0000 2 2
Washer

Location	Loc Qty	Loc Code
ST347	10	
105059	10	

MS20600-AD4W3 Purchased No 150 Each 1,335.000 2 2
Cherry Rivets

Location	Loc Qty	Loc Code
ST321	1335	
107939	754	
111636	581	

MS21042L3 Purchased No 150 Each 3,053.000 6 6
Nut

Location	Loc Qty	Loc Code
ST300	3053	
114784	9	
115835	544	
116391	900	
116540	800	
116549	800	

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Shop Packet Print

Page 5

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Thursday, January 27, 2011 1:11:28 PM

Page 6

Work Order ID: 65939

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

150

Each

278.0000

12

12



WASHER

64/2/16

Location

Loc Qty

Loc Code

ST275

278

18057

278

18057

Thursday, January 27, 2011 1:11:28 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

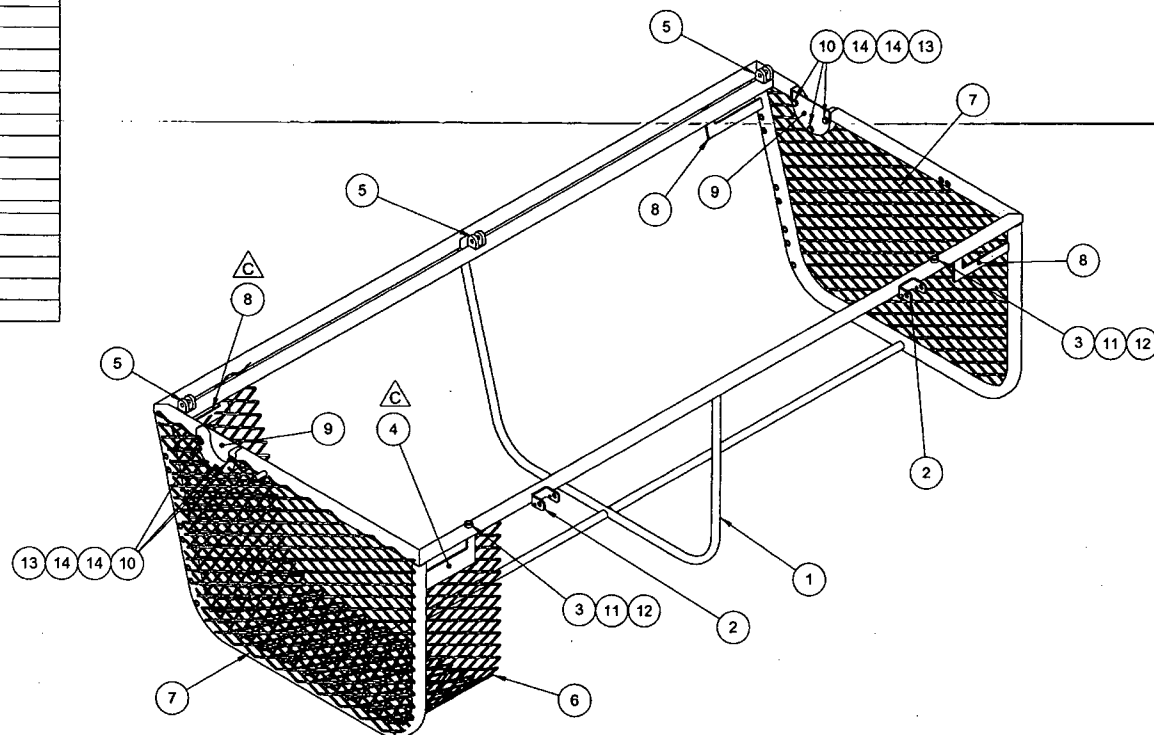
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4017-041	SHORT BASKET BASE ASSY (350)
1	1	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
2	2	D2581	MOUNTING BRACKET
3	2	D2931	BUMPER
4	1	D3913-15	WIDE HANDLE PLATE
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-3	MESH (350 BASKET SHORT BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D4017-041 SHORT BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

ECN 10-596
RELEASED
10.06.12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 28.8 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

#65939

C	ITEM #4 NOW INSTALLED OUTBOARD (C4-1, C5-1, B5-2 AND D6-2). REASON: ELIMINATE INTERFERENCE PREVENTING INSTALLATION OF RECEIVER ASSEMBLIES.	MB	10.07.23
B	QTY 1 D4021-1 REPLACED WITH QTY 1 D3913-15; AN3-10A BOLT WAS AN3C10A; NAS1149F0332P WASHER WAS NAS1149C0332R; SECTION F-F UPDATED (D6-2); ITEMS RENUMBERED, DETAIL D UPDATED (A4-3)	JPH	10.03.25
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN			
CHECKED			
MFG. APPR.	J.F.S.		
APPROVED			
DE APPR.			
DATE	10.07.23		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4017** REV. C
SHEET 1 OF 5

TITLE **SHORT BASKET BASE ASSY (350) _NTS** SCALE

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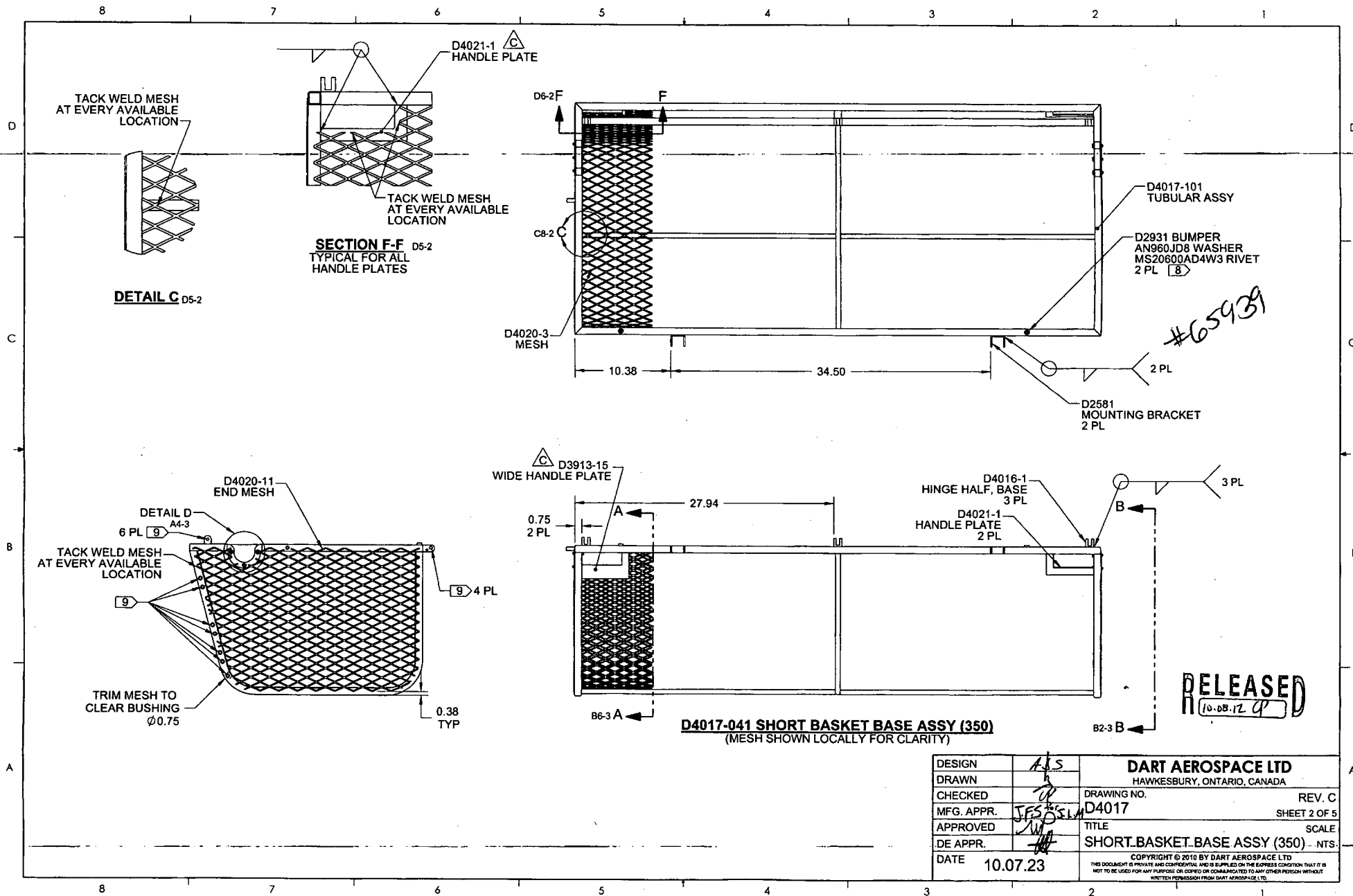
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DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JES	D4017	SHEET 2 OF 5
APPROVED	JW	TITLE	SCALE
DE APPR.	JW	SHORT.BASKET.BASE ASSY (350) - NTS.	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

D

D

C

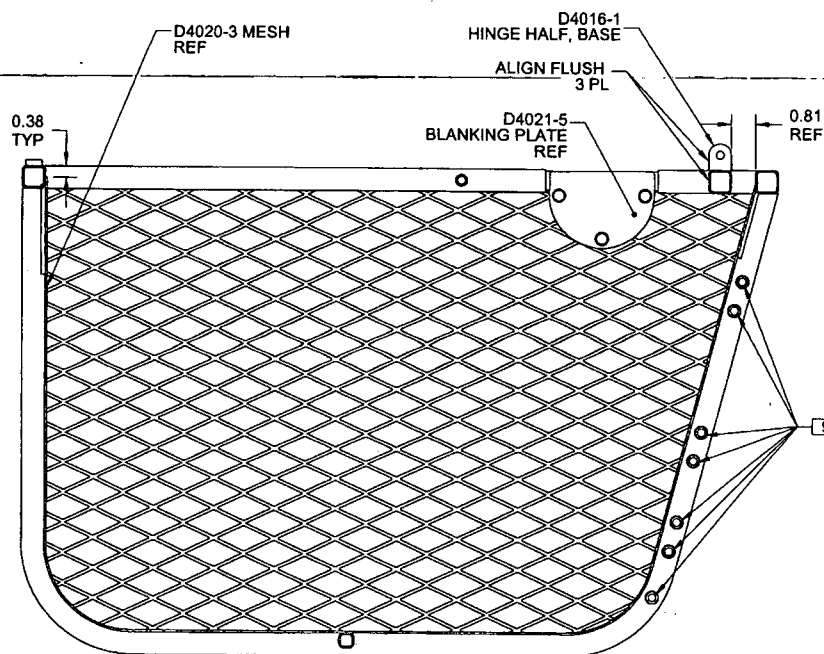
C

B

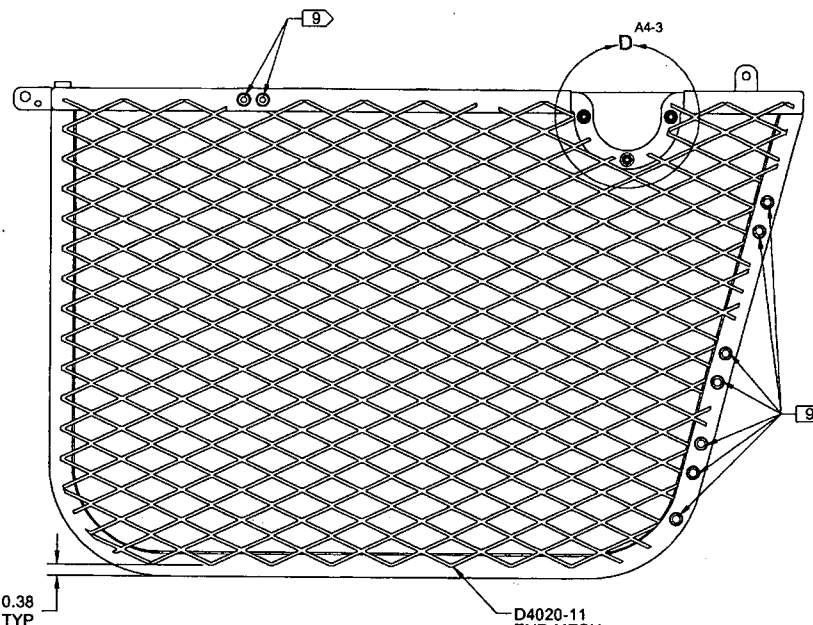
B

A

A



SECTION A-A A5-2



SECTION B-B A2-2

8
D4021-5
BLANKING PLATE

8
AN3-10A
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
3 PL

TRIM MESH LOCALLY
Ø0.50 - Ø0.60
TO CLEAR FASTENERS

DETAIL D D1-3 B8-2

#65939

RELEASED
10.08.12

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JFS to ELM	D4017	SHEET 3 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	SHORT-BASKET-BASE ASSY (350) -NTS-	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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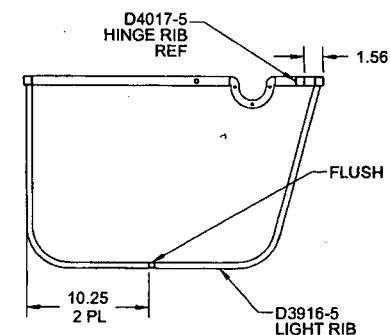
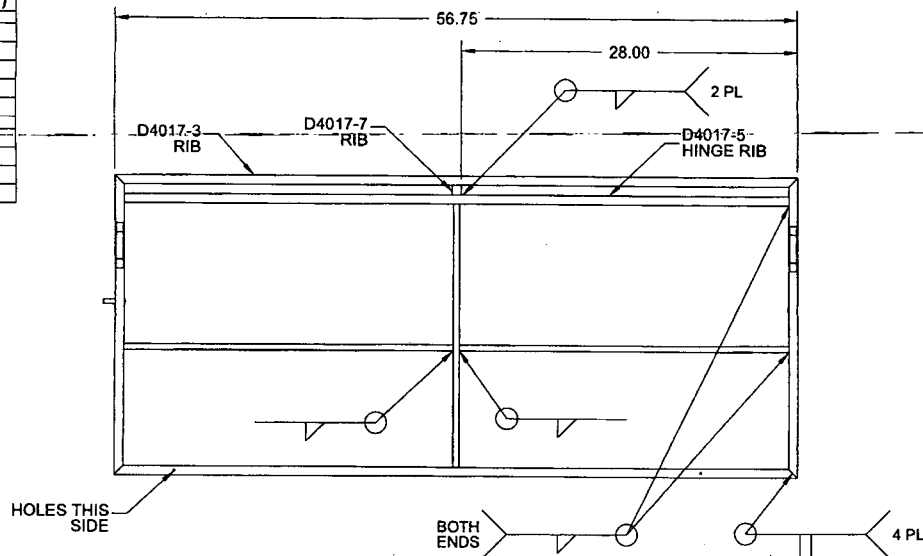
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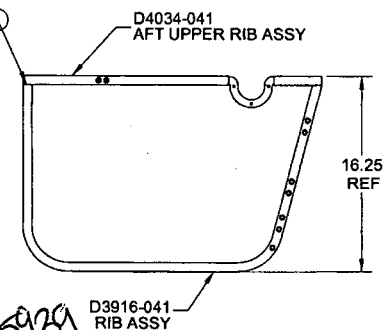
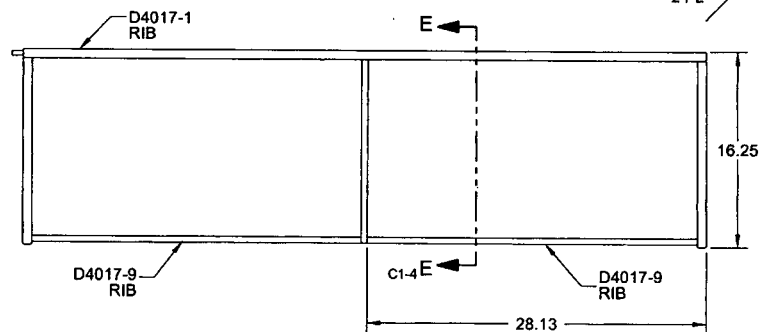
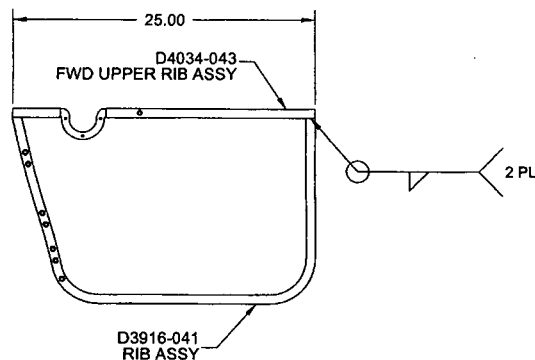
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
1	1	D4017-1	RIB
2	1	D4017-3	RIB
3	1	D4017-5	HINGE RIB
4	1	D4017-7	RIB
5	2	D4017-9	RIB
6	2	D3916-041	RIB ASSY
7	1	D3916-5	LIGHT RIB
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY



SECTION E-E A4-4



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 15.26 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4017-101
 - 9) WELD PER DART QSI 004

8 D4017-101 TUBULAR ASSY (350 SHORT BASKET)

DESIGN	AKS	DART AEROSPACE LTD	
DRAWN	AKS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AKS	DRAWING NO. D4017	REV. C
MFG. APPR.	SIS		SHEET 4 OF 5
APPROVED	JM	TITLE	SCALE
DE APPR.	JM	SHORT BASKET-BASE ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
10.08.12

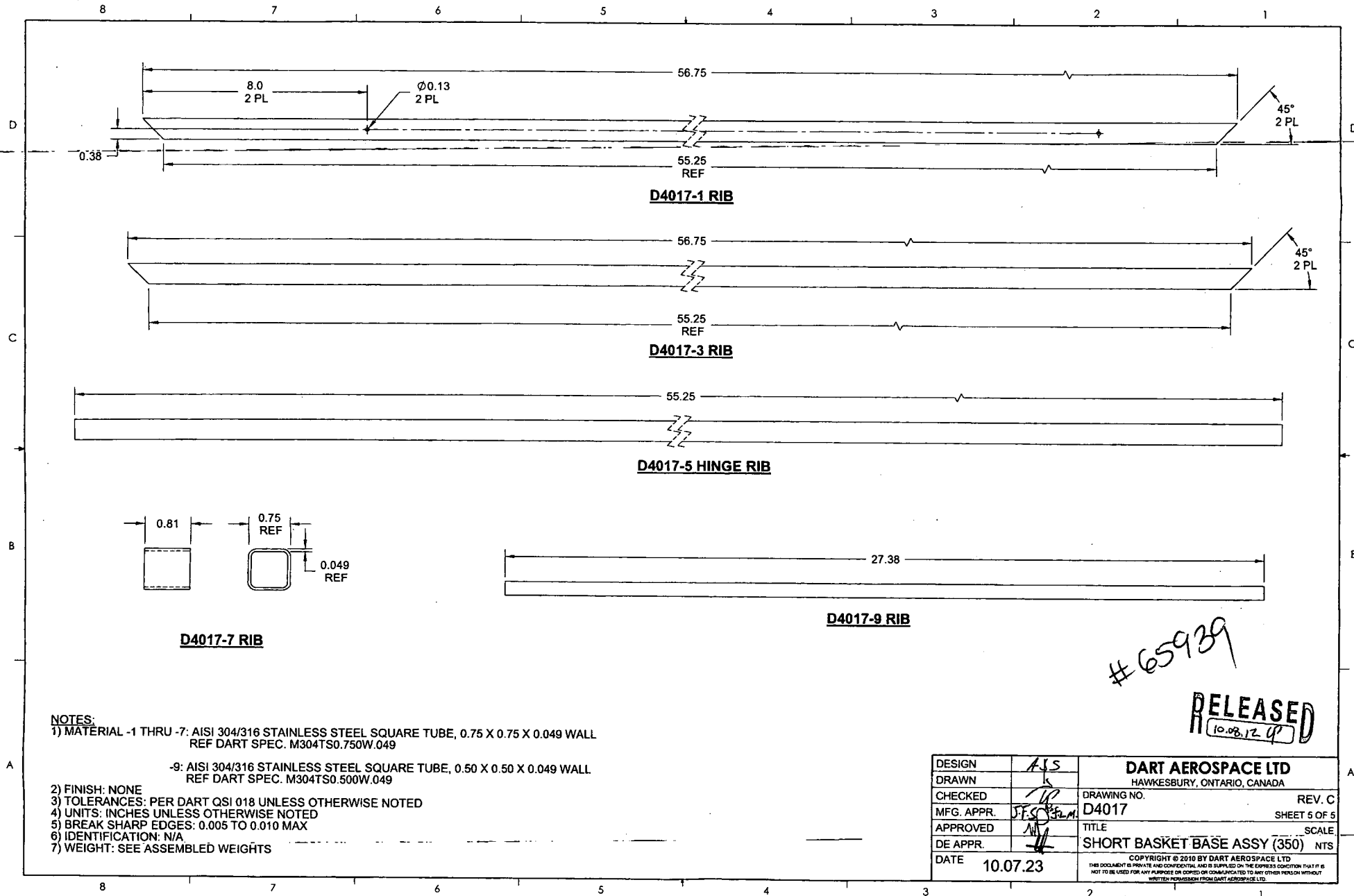
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



#65939

RELEASED
10.08.12.9

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	K	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JFS	D4017	SHEET 5 OF 5
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	SHORT BASKET BASE ASSY (350)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries